

# Work Order ID 66674

Wednesday, February 23, 2011 3:25:40 PM



Page 1

Item ID: D205-706-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-02-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN-D412-706	Rev A								
100		0.00							
	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo								
	Photocopy bluefile and create labels per PPP D205-706-013 CHG002								
110		0.00							
	Pick Kit								
Packaging		0.00							
Packaging	Memo								
120		0.00							
	QC4- 100% Inspect kits for completeness								
QC		0.00							
Quality Control	Memo								

*Suloe/25*

*for CL 11-6-9*

*JB* *[Signature]* *11/06/08*

*Suloe/25*

*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66674**

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Page 2

Item ID: D205-706-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPPD205-706-013 Location: <u>31</u> PPP Rev: <u>D</u>	0.00							
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/8/25

11/8/25

CL1108125

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Wednesday, February 23, 2011 3:25:46 PM

Work Order ID: 66674

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister





Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D  
KJ/JLM IPP Rev:F 10.05.10 as per  
chg002 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			110	Each	732.0000	4	4	✓		
<div> <div>Location</div> <div>ST350</div> <div>115016</div> <div>115371</div> <div>116632</div> </div> <div> <div>Loc Qty</div> <div>732</div> <div>56</div> <div>500</div> <div>176</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
AN814-6D  Plug		Purchased	No			110	Each	5.0000	1	1	✓		
<div> <div>Location</div> <div>ST329</div> <div>114742</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN815-6D  Union-M-Flare		Purchased	No			110	Each	10.0000	2	2	✓		
<div> <div>Location</div> <div>ST329</div> <div>116419</div> </div> <div> <div>Loc Qty</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN833-6D  Elbow, Bulkhead-M-Flare		Purchased	No			110	Each	4.0000	3	3			
<div> <div>Location</div> <div>ST333</div> <div>115705</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

JB

115371

117946

JB

117514

JB

11/06/08

118006

10/6/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 23, 2011 3:25:46 PM

Work Order ID: 66674

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN924-6D Purchased No  
Nut

110 Each 6.0000

4

4



117909

JB

W

Location

Loc Qty

Loc Code

ST335

6

114988

1

116583

5

AN960JD10 NAS1149D0363J Purchased No  
Washer

110 Each 24.0000

8

8



116583

JB

W

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

18

105792

2

112279

16

AN960JD10L NAS1149D0332J Purchased No  
Washer

110 Each 6.0000

4

4



117291

JB

W

Location

Loc Qty

Loc Code

ST335

6

11912

6

AN960JD916 Purchased No  
WASHER

110 Each 0.0000

2

2



116683

JB

11/06/08

W

NAS1149D0363J

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Picklist Print

Wednesday, February 23, 2011 3:25:47 PM

Page 3

Work Order ID: 66674

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2001-4 Manufactured No

110 Each

4.0000

1

1 ✓



Valve Assembly (1/4")



68025

JB

✓

LocationLoc QtyLoc Code

ST002

4

55525

1

56682

3

D3262-041 Manufactured No

110 Each

1.0000

1



Canister Assembly



B69405 11/6/08

LocationLoc QtyLoc Code

ST144

1

63600

1

D3264-1 Manufactured No

110 Each

3.0000

2

2 ✓



Bracket

0360  
68026x1 JB  
B70614 (x) 11/8/25LocationLoc QtyLoc Code

ST144

3

59451

3

D3297-1-0121 Manufactured No

110 Each

3.0000

1

1 ✓



HOSE ASS'Y



JB 11/04/08

LocationLoc QtyLoc Code

ST194

3

59542

3

59542

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

# Picklist Print

Wednesday, February 23, 2011 3:25:48 PM

Page 6

Work Order ID: 66674

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3302-1  
  
 Doubler

Manufactured No

110 Each

5.0000

1

1



70256

JB

*[Signature]*

Location

Loc Qty

Loc Code

ST143

5

54577

1

60251

4

D3302-3  
  
 Doubler

Manufactured No

110 Each

8.0000

1

1



JB

*[Signature]*

Location

Loc Qty

Loc Code

ST142

8

54578

8

54578

4

MS21042L3  
  
 Nut

Purchased No

110 Each

2,684.000

4

4



JB

*[Signature]*

Location

Loc Qty

Loc Code

ST300

2684

110844

4

114784

9

115835

171

116391

900

116540

800

116549

800

116549

1

MS21919-WDG12  
  
 Clamp

Purchased No

110 Each

27.0000

1

1



JB 11/06/08

*[Signature]*

Location

Loc Qty

Loc Code

ST307

27

107534

27

107534

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 23, 2011 3:25:48 PM

Work Order ID: 66674

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG16 Purchased

No

110 Each

8.0000

2

2

✓



Clamp

Location

Loc Qty

Loc Code

ST307

8

114523

8

110 Each

54.0000

5

5

✓

MS21919-WDG9

Purchased

No



Clamp

Location

Loc Qty

Loc Code

ST307

54

111578

14

116702

40

110 Each

4.0000

2

2

✓

MS21920-42

Purchased

No



CLAMP(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

ST451

4

115358

4

110 Each

18.0000

5

5

✓

MS28778-6

Purchased

No



Packing

Location

Loc Qty

Loc Code

ST294

18

113422

17

114494

1

113422

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 8

Wednesday, February 23, 2011 3:25:49 PM

Work Order ID: 66674



Parent Item: D205-706-013



Parent Item Name: Fuel Purge Canister

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS35489-11

Purchased

No

110

Each

19.0000

1

1



GROMMET



JB 11/06/08

Location

Loc Qty

Loc Code

ST295

19

109166

19

109166

Wednesday, February 23, 2011 3:25:49 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**REFERENCE ONLY****5. PARTS LIST**

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
1	1	1	D3262-041	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0085	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
1	1		D3298-001	TUBE ASSEMBLY
1			D3298-003	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
1	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
1	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
4	4	4	AN3-5A	BOLT
1	1	1	AN814-6D	PLUG
3	2	2	AN815-6D	UNION
		1	AN816-6D	NIPPLE
1			AN832-6D	UNION
2	3	1	AN833-6D	ELBOW
		1	AN919-6D	REDUCER
5	4	1	AN924-6D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER

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Revision: **A**

Date: 04.11.30

5

2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
10	5	5	MS28778-6	O-RING
1	1	1	MS35489-11	GROMMET

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Revision: **A**

Date: 04.11.30